

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005573**Date Inspected:** 04-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Shen Fuyou**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segments and cross beams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 19

This QA performed Ultrasonic Testing (UT) and Magnetic particle Testing (MT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows:

BP025-003-001, 002 and 003

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Yulong (062817) perform SAW welding on weld joint identified as CB205D-001-007. ZPMC QC identified as Mr. Lu Li Qing was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as Miss Lu Shiqin (044755) perform SAW welding on weld joint identified as SEG-005*-005. ZPMC QC identified as Mr. Lu Li Qing was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to

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be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Xia Jun (068253) perform SMAW repair welding on weld joint identified as DP-575-252. ZPMC QC identified as Mr. Li Jie was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-repair.

This QA performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows:

SEG035A-006/ SEG031B-013/ SEG027B-022, 023 and 025.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
